

C L A I M S

1. Method for producing a packaging material (C) usable for forming self supporting packaging items, which packaging material has the form of a quasi endless rollable web and consists of a foam layer (B) of a first polyolefin coated on at least one side with a coating film (A), **characterized** in that in a first method step (1) a single-layer or multilayer coating film (A) is produced by extrusion or coextrusion which coating film (A) consists of a second polyolefin or has at least one surface layer (14) consisting of a second polyolefin, that in a second method step (2) a foam sheet (B) of the first polyolefin is produced by expansion and extrusion, that in a third method step (3) the polyolefin foam sheet (B) is coated with the coating film (A) by extrusion lamination consisting of guiding the polyolefin foam sheet (B) and the coating film (A) with its surface of the second polyolefin facing toward the polyolefin foam sheet together, extruding a further bonding layer (30) of a third polyolefin between them and applying pressure to the composition, wherein the first, second and third polyolefin are all based on the same main monomer. 5 10 15
2. Method according to claim 1, characterized in that the further bonding layer (30) has a thickness of 5 to 30 µm. 20
3. Method according to claim 1 or 2, characterized in that the third polyolefin is based on a different main monomer than the first and second polyolefin. 25

4. Method according to claim 1 or 2, **characterized** in that the polyolefin foam sheet being coated by extrusion lamination in a third method step (3) is a polyolefin foam sheet coated on one side in a previous coextrusion step. 5
5. Method according to claim 1 to 4, **characterized**, in that the main monomer of the polyolefin of the foamed layer is propylene. 10
6. Method according to one of claims 1 to 5, **characterized** in that the coating film (A) is produced by coextrusion of a barrier layer (11) of ethylene-vinyl-alcohol-copolymer, of a bonding surface layer (14) of polypropylene forming one surface of the film, a sealing layer (15) of polyethylene forming the other surface of the film, a first adhesive layer (12) between the barrier layer (11) and the bonding layer (14) and a second adhesive layer (13) between the barrier layer (11) and the sealing layer (15), wherein the adhesive of the first adhesive layer (12) is a propylene copolymer and the adhesive of the second adhesive layer (13) is an ethylene copolymer. 15 20
7. Method according to one of claims 1 to 5, **characterized** in that the coating film (A) is produced by coextrusion of a barrier layer (11) of ethylene-vinyl-alcohol-copolymer, of a bonding layer (14) of polypropylene forming one surface of the film, a protecting layer of poly- 25
second adhesive layer (13) between the barrier layer (11) and the 30
sealing layer (15) forming the other surface of the film and the

8. Method according to one of claims 1 to 5, **characterized** in that the coating film (A) is produced by coextrusion of a bonding layer (14) of polypropylene forming one surface of the film, a sealing layer (15) of polyethylene forming the other surface of the film and an adhesive layer (16) between the sealing layer (11) and the bonding layer (14). 5
9. Method according to one of claims 1 to 8, **characterized** in that the polyolefin used for the production of the foam sheet is a mixture of long chain branching polypropylene and an ethylene-propylene-copolymer. 10
10. Packaging material (C) consisting of a foam layer (B) of a first polyolefin coated on at least one side with a coating film (A), which packaging material is produced by a method according to one of claims 1 to 9, **characterized**, in that the coating film (A) of the foamed layer (B) has two bonding layers (30, 14) which are positioned on the foam layer (B) and consist of further polyolefins based on the monomer which is the main monomer of the first polyolefin. 15 20
11. Packaging material according to claim 10, **characterized** in that it features further layers (11, 12, 13, 15, 16) on the outside of the at least one bonding layer (30, 14). 25
12. Packaging material according to claim 11, **characterized** in that the 30

13. Packaging material according to one of claims 10 to 12, **characterized** in that the first polyolefin and the further polyolefins are propylene based polyolefins.

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14. Packaging material according to claim 13, **characterized**, in that the bonding layer (14) together with the further bonding layer (3) have a thickness of 5 to 60 μm .

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15. Packaging material according to one of claims 10 to 14, **characterized** in that at least one of the outermost layers of the packaging material is a sealing layer (15) consisting of low density polyethylene or of peelable polyethylene.

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16. Packaging material according to one of claims 10 to 15, **characterized**, in that it features a coating film on both sides and that the two coating films are dissimilar.

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